

## Claims

Sub 917 Rockshaft bearing block structure for rotatably mounting a portion of a rockshaft having circular cross-section on an implement frame, the bearing block structure comprising:

first and second bearing block sections, the sections including first and second arc-shaped cavities;

first and second arc-shaped bearing block inserts received in the respective first and second arc-shaped cavities;

anti-rotation structure projecting radially inwardly from the bearing block sections between the cavities and contacting end portions of the bearing block inserts, thereby preventing substantial relative sliding movement between the inserts and the cavities; and

connector structure securing the first and second bearing block sections and the inserts around the rockshaft.

2. The structure of claim 1 wherein the anti-rotation structure comprises a clip sandwiched between the bearing block sections.

3. The structure of claim 2 wherein the clip comprises a planar member and the bearing block sections include indexing structure preventing movement of the clip relative to the bearing block sections.

4. The structure of claim 3 wherein the indexing structure comprises a projection on one of the bearing block sections.

5. The structure of claim 1 wherein the bearing block inserts are identical.

6. The structure of claim 1 wherein the bearing block inserts each have a generally half cylinder shape.

7. The structure of claim 6 wherein the inserts are identical and fabricated from a wear-resistant polyethylene material.

8. The structure of claim 2 wherein the connector structure includes a bolt sandwiching the clip between bearing block sections.

9. The structure of claim 1 wherein the connector structure includes bolts extending through the bearing block sections and connected to the implement frame.

10. The structure of claim 1 wherein the anti-rotation structure includes a

cavity end portion.

12 11. In a rockshaft bearing block structure for rotatably mounting a portion of a rockshaft having circular cross-section on an implement frame, the bearing block structure including first and second bearing block sections with first and second cavities, wear insert structure comprising:

first and second bearing block inserts having outer surfaces complimentary to the first and second cavities and adapted for support therein, the bearing block inserts including inner surfaces defining a substantially cylindrical rockshaft bearing wear area when the inserts are supported in the cavity; and

wherein the bearing block inserts include a contact area adapted for non-rotatably indexing the inserts relative to the bearing block structure.

12. The wear insert structure as set forth in claim 11 further comprising anti-rotation structure located within the cavities, the anti-rotation structure including a surface engaging the contact area thereby preventing substantial relative sliding movement between the bearing block inserts and the cavities.

13. The wear insert structure as set forth in claim 11 wherein the bearing block inserts comprise identical half portions each conforming generally to the shape of a half cylinder.

14. The wear structure as set forth in claim 13 wherein the contact area comprises an end portion of the half portions.

15. The wear structure as set forth in claim 12 further comprising anti-rotation structure adapted for support between the bearing block sections within the cavities and having an edge defining an insert wear warning device providing an audible signal when the inserts wear to a preselected level.

16. The wear structure as set forth in claim 13 wherein the bearing block inserts have a shape conforming to and non-rotatably received in the first and second cavities.

17. The wear structure as set forth in claim 13 wherein the inserts are fabricated from a polyethylene material.

18. A method of fabricating bearing block structure for rotatably mounting a portion of a rockshaft having circular cross-section on an implement frame, the

method comprising:

providing a split bearing block having first and second sections with first and second cavities, respectively;

providing first and second non-metallic wear resistant inserts;

attaching the first section to the implement frame and inserting the first insert into the first cavity;

inserting the second insert into the second cavity; and

securing the first and second sections with the inserts in the cavities together around the rockshaft with the inserts in contact with the rockshaft.

19. The method as set forth in claim 18 wherein the step of providing a split bearing block includes preventing rotation of the first insert by providing the first cavity with an end portion and contacting an end of the first insert with the end portion.

20. The method as set forth in claim 19 wherein the step of providing the end portion comprises inserting a clip between the first and second sections.